

Work Order ID 74821

74821

Page 1

Friday, October 07, 2011 8:46:54 AM

Item ID: D3884-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Inboard LH
 Start Date: 10/7/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 10/14/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: Date: 11-10-7 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3884	B								

100
100
 HAAS 1
 HAAS CNC vertical machine #1
 HAAS CNC VERTICAL MACHINING #1
 0.00
 Memo
 Program Batch No. 74821
 Double check by:
 1-Machine Step No 1 per Folio FA818 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA818 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA818 and inspect per Dimension Sheets
 12/05/30
 12/05/31

110
110
 QC
 Quality Control
 QC2-Inspect parts off machine FAI/FAIB
 0.00
 Memo
 12/05/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC8- Inspect parts - second check 0.00

120

QC

Quality Control

Memo

0.00

1206/1

4

130 Chemical Conversion Coat per QSI005 4.1 0.00

130

HandFinish

Hand Finishing

Memo

0.00

4 MB 1254

140 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

140

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:10
320°F
10:40

0.00

4X 12/6/04

W 121134

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150						4	4		
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <u>55424</u>	0.00							
160						4			
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

4 4 4 12/06/08

4 Sac 12/06/05

12/6/5

MR 12-06-05

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Picklist Print

Friday, October 07, 2011 8:47:03 AM

Page 1

Work Order ID: 74821

Parent Item: D3884-1

Start Date: 10/7/2011

Required Date: 10/14/2011

Parent Item Name: Saddle, Inboard LH

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-017 Saddle Billet		Manufactured	No				Each	4.0000					
<div><div><div><div><u>Location</u></div><div>MAT047</div><div>✓ 51835</div></div><div><u>Loc Qty</u></div><div>4</div><div>4</div></div><div><div><u>Loc Code</u></div><div></div></div></div>													

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	74821
Description: Saddle, Inboard, LH		Part Number:	D3884-1
Inspection Dwg: D3884	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	2.870	2.880		2.877	2.876	2.876	2.876		
B	1.433	1.443		1.440	1.438	1.439	1.439		
C	0.638	0.658		.640	.641	.640	.641		
D	3.895	3.905		3.898	3.900	3.900	3.900		
E	0.257	0.262		.259	.259	.259	.259		
F	0.605	0.625		.608	.608	.609	.609		
G	1.120	1.130		1.126	1.126	1.126	1.126		
H	2.245	2.255		2.251	2.250	2.250	2.250		
I	2.000	2.020		2.007	2.001	2.005	2.004		
J	0.140	0.175		.158	.157	.158	.157		
K	1.265	1.285		1.267	1.268	1.266	1.266		
L	0.115	0.135		.125	.126	.125	.125		
M	0.240	0.260		.248	.248	.248	.248		
N	0.110	0.140		.140	.140	.140	.140		
O	0.240	0.260		.252	.250	.250	.250		
P	2.826	2.886		2.865	2.864	2.865	2.866		
Q	0.178	0.198		.188	.188	.188	.188		
R	0.140	0.165		.147	.147	.148	.149		
S	0.720	0.780		.765	.760	.763	.763		
T	1.220	1.280		1.264	1.260	1.260	1.260		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		5.999	5.999	5.999	6.000		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		.501	.500	.500	.498		
Y	0.020	0.040		.028	.032	.030	.032		
Z	0.313	0.318		.315	.315	.315	.315		
AA	0.760	0.765		.760	.760	.760	.760		
AB	0.215	0.220		.219	.219	.219	.219		
AC	0.316	0.321		.3175	.3175	.3175	.3175		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.000	1.000	1.000	1.000		
AF									
Accept/Reject									

Measured by:	amf
Date:	12/05/31

Audited by:	SA
Date:	12/06/11

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	[Signature]

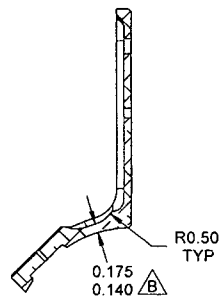
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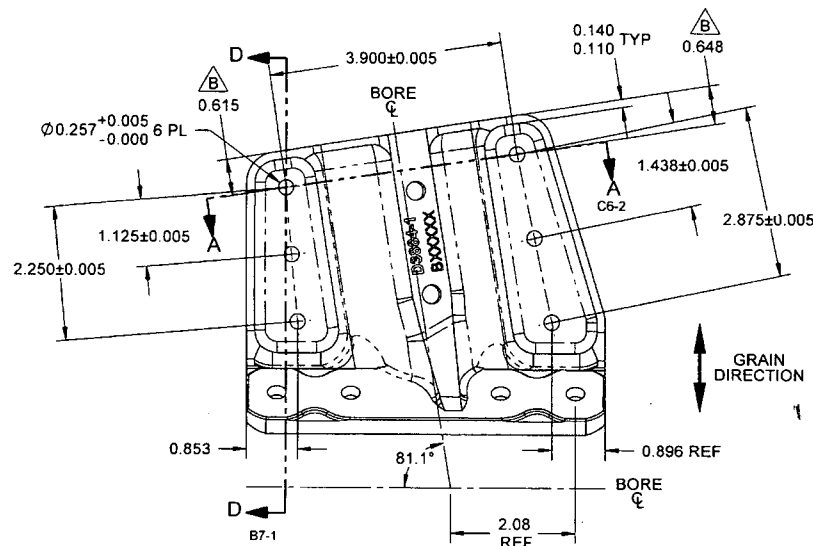
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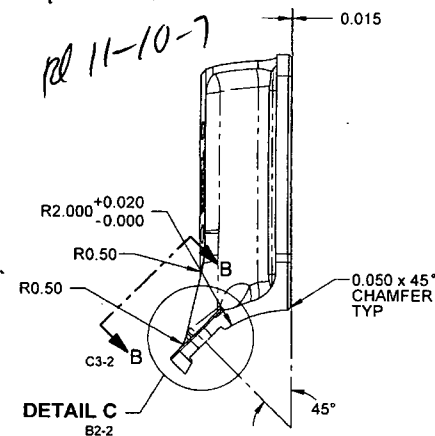
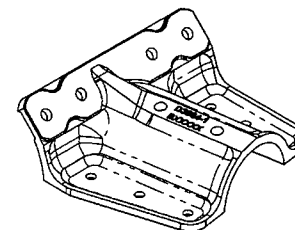


SECTION D-D B6-1



D3884-1 SADDLE, INBOARD LH (SHOWN)
D3884-2 SADDLE, INBOARD RH (OPPOSITE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74821



RELEASED
07/15/40

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER QQ-A-250/12 OR AMS-QQ-A-250/12 OR AMS-QQ-A-250/12 (REF DART SPEC. D6101-017)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 0.71 lbs

B	D6101-017 WAS D6102-017. ZN A6-1; ADD NOTE. ZN C4-2; ADD R0.031. ZN C2-2; INCREASED TOLERANCE 0.175 WAS 0.165. ZN B7-1; ADD 0.615. ZN C6-1; ADD 0.648. ZN C4-1; ADD 0.250. ZN D6-2; ADD 0.060. ZN C2-2: 0.75 WAS 0.65. ZN D7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3884	SHEET 1 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	INBOARD SADDLE	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

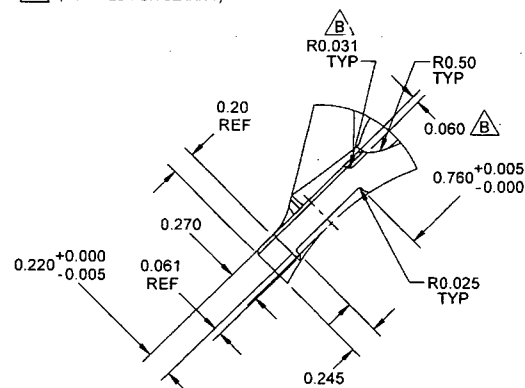
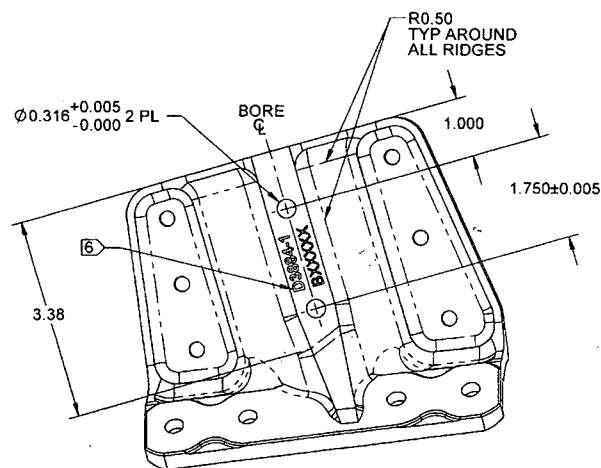
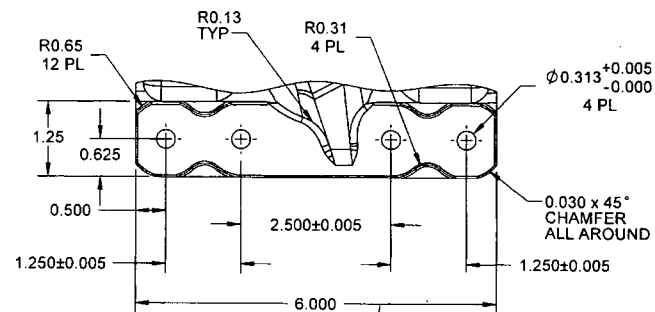
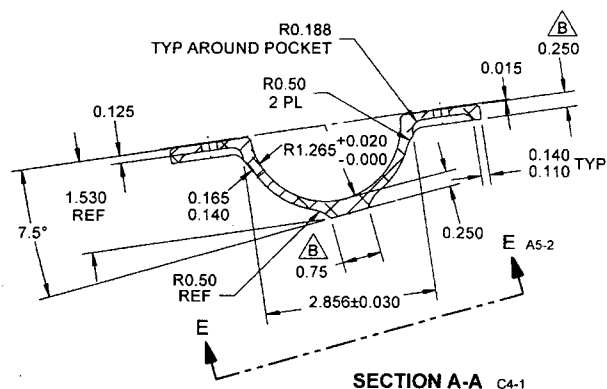
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DETAIL C B3-1
SCALE 2X

RELEASED
09/07/15

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3884	SHEET 2 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	INBOARD SADDLE	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.	
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